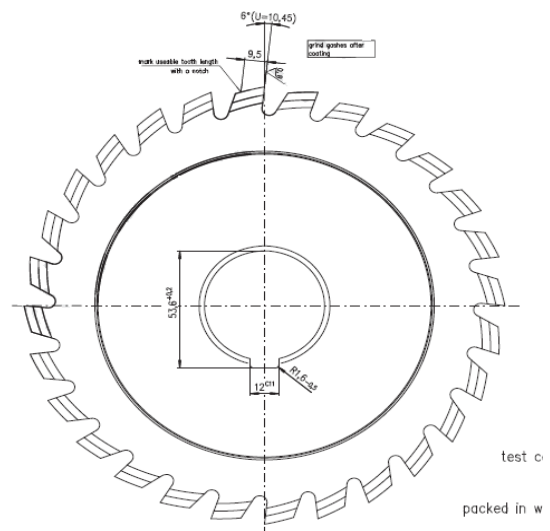









## Rack Milling Cutter Ø200 Z28

A12-020

Resharpener cycles for helical rack milling cutters with tapered wheel: 1 pass pregrinding, 4 passes finishing with increments of 0.01 mm, 2 passes sparkout with below mentioned feeds for a total material removal of 0.2 mm.



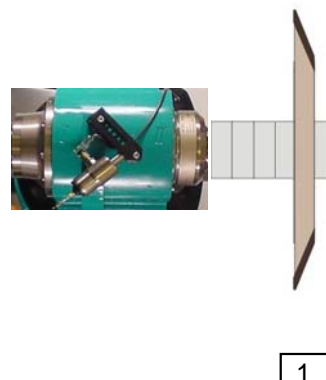
### 1. Cycletime for Resharpener

<b>Workpiece:</b> Ø 200 mm, Z 28, Length 168 mm, Helix 10°, RA 6° Material HSS				
<b>Operations</b>				
Feed [mm/Min]	2000	150	400	800
Power [kW]		3	2	1
Cutting feed [m/s]		32	32	32
Used wheels				
Grinding time [s]	6	2088	1717	1717
Total cycle time	92 Min 9			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1V1 Ø125 B106 20°
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### 3. Machine and Software Requirements

Machines:	5 axes CNC grinders : NORMA CFG	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:	Dresser, Tailstock		
Responsible engineer:	OP, 30.6.2011		

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